

Work Order ID 66624

Page 1

Wednesday, February 23, 2011 8:08:08 AM

Item ID: D3272-1

Accept



Setup Start



Revision ID:

Item Name: Step

Stop



Start Date: 2/23/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11-02-23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100



Large Fab

Large Fab

Memo

0.00

0.00

SQUARE ONE END BEFORE CUTTING OTHER END

11-03-08 - 1 - 8

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Pc 11-03-09 - - - - -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Required Date: 3/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

120



Packaging

Packaging

130



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampIdentify as per dwg & Stock Location: WA

0.00

11-03-09

*10**✓**11/3/9*

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/3/9**11-03-9
10*

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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 8:08:14 AM

Page 1

Work Order ID: 66624



Parent Item: D3272-1



Parent Item Name: Step

Start Date: 2/23/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	107.6440	1	10		2/11/03/09	

Step Extrusion

Location	Loc Qty	Loc Code
WA	107.644	
55214	1.92	
58544	1	
61208	4.724	
64409	100	10

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NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>HF</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01		NEW ISSUE
B	07.05.18		D3272-1 WAS D2622-120

RELEASED

07.06.04-*HF*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *114424*
21/11/2023

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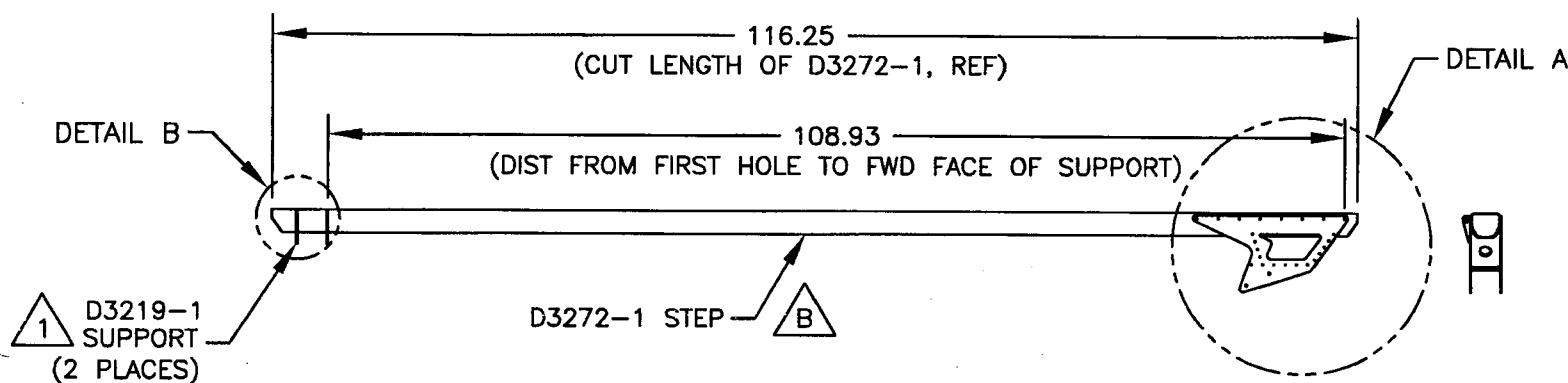
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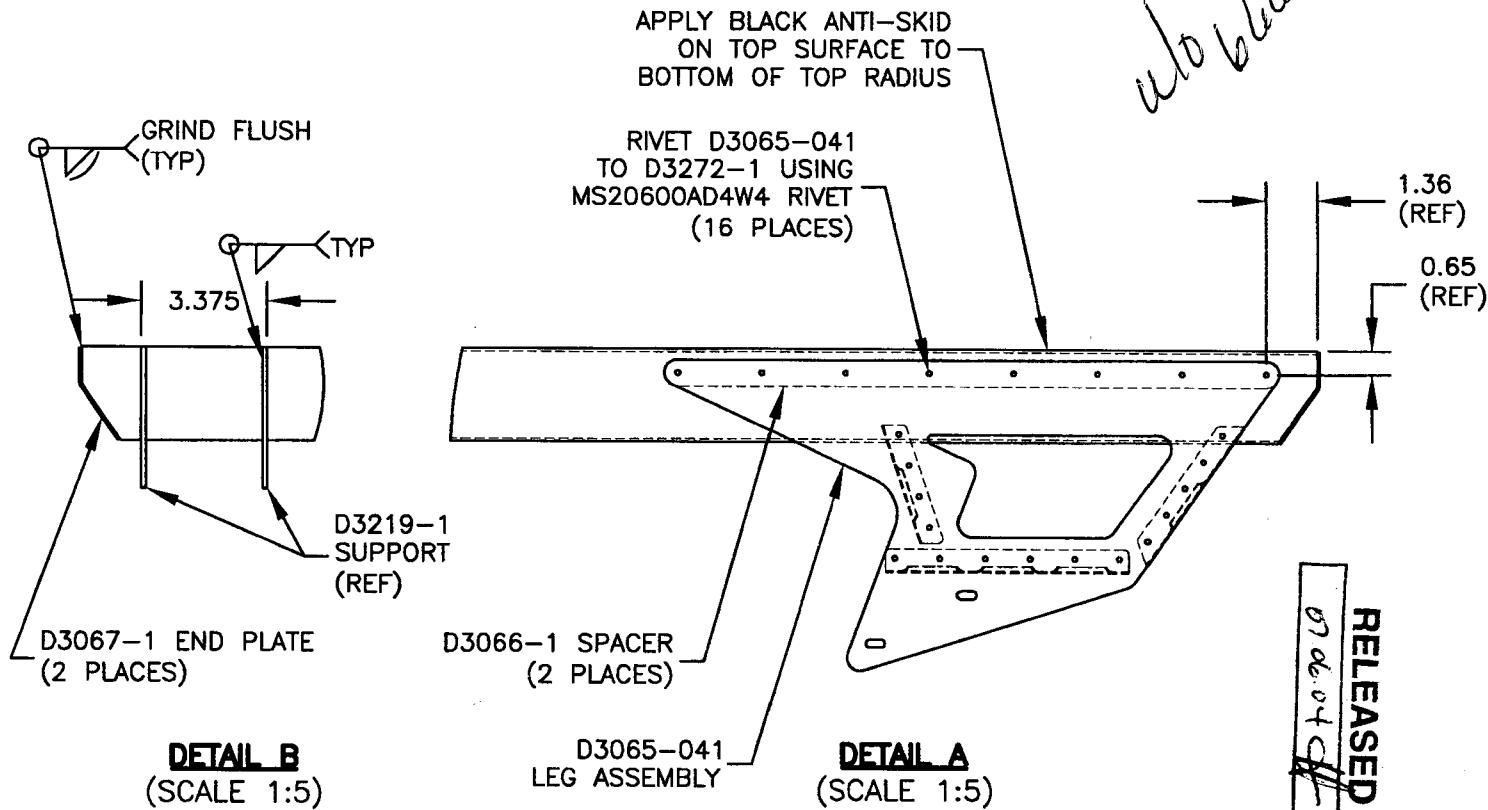
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
REVISION	DATE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	
<i>cc</i>	<i>cc</i>	D3272	SHEET 2 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, LH LONG
SCALE	1:20	SCALE	1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
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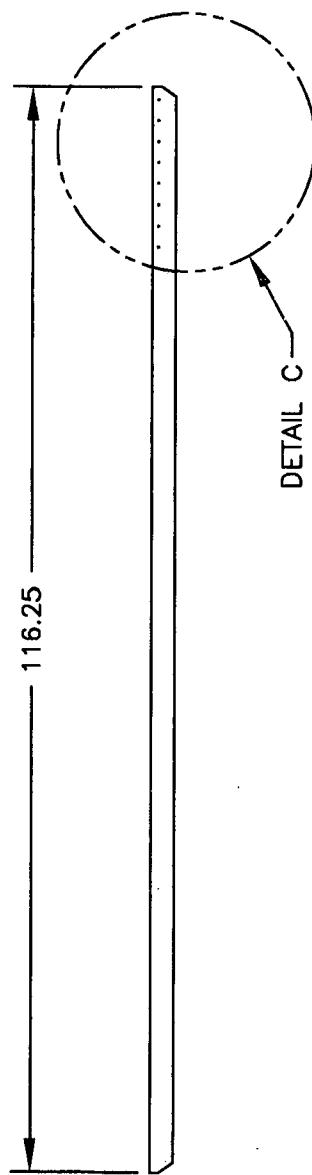
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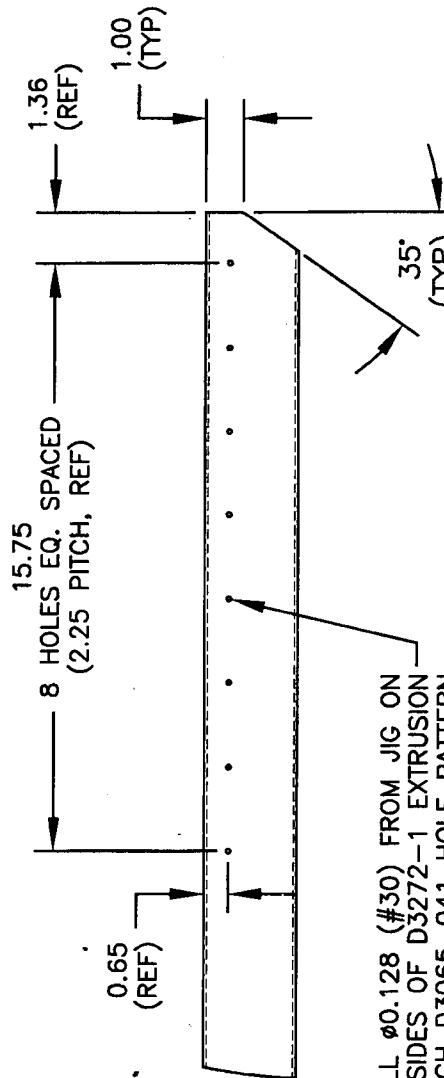
DART

DESIGN <i>QP</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>AS</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

*Welded
30*



RELEASED
07.06.04 *[Signature]*

DETAIL C
(SCALE 1:5)

DRILL #0.128 (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

W/O:		WORK ORDER CHANGES					
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